

042-311

Dart Aerospace Ltd.

Date: Thursday, 19/03/2009 11:03:08 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206 L HIGH GEAR SKIDTUBE
<b>Job Number</b>	: 46575A		
<b>Estimate Number</b>	: 10539		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206642341
<b>This Issue</b>	: 19/03/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2650 REV F
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 44044	<b>Drawing Revision</b>	: KF
	<b>Type</b> : SKIDTUBES	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 15/04/2009
<b>Checked &amp; Approved By</b>	: JUD 09.03.19	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM Est Rev: I 08-09-29 revF as per dwg DD verified by:ec Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by:EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

2.0

~~D2620~~

D26001240

Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B10427

B10427

Am: 09-03-30

3.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2647

Fwd Cap

B43846 BE 09/03/30

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

Am: 09-03-30

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

Am: 09-03-30

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod

m110676/m109213 BE 09/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 19/03/2009 11:03:08 AM  
User: Julie Dawson

## Process Sheet

Customer: GJ-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 46575A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 4-Grind weld flush to cap on top surface only. *bt 09/03/30*
- 5-Cut aft end to length as per dwg D2650
- 6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"
- 7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".
- 8-Open Aft Cap Hole using #6 Drill Bit
- 9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail
- 10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650
- 11-Deburr and Blow out all chips from inside the tube
- AWM 9-3-31*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*AWM 9-3-31*

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DD 9-3-31*

7.0

D26545

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 - D2654-5

Web

*B-35993*

*AWM 9-3-31*

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: *7-3-31* Time: *9:00*

*AWM 9-3-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 19/03/2009 11:03:08 AM  
User: Julie Dawson

## Process Sheet

Customer: GU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 46575A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

Finish Date: 9/4/11 Time: 8:00AM

A/R Sikaflex-291

Sikaflex expiry date:

M111088

19/01/01

ALUM 9-3-31

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/01

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

19 D2649

Crossbolt spacer

R 45317 BE 09/04/01

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M109213 BE 09/04/01

PTC

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

M 9-4-1

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

B 33061 D M 9-4-2

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch



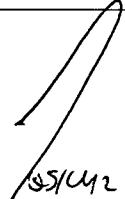
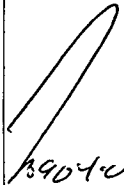
2 CCR264SS3-3

Rivets

M 110625 M 9-4-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-341 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 09/04/02  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR 46575A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0904/01	11.0	Prior to 9.0 inspection a tiny dent was found 3" behind the fwd saddle location, about .300" in diameter, .0020" max depth R. C. Handling, storage.		- fill affected area with weld per QSI 004 Reel A/RM 109213 - grind smooth. dent is beside the web, and will be under the wing walk	BE 09/04/01	 09/04/02		

NOTE: Date & initial all entries

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## Process Sheet

Customer: CJ-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 46575A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch:

M110139 ② M 9-4-2

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

① M 9-4-2

16.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/04/02 ④

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/02 ④

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HL 09-04-13 ④

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

\*\*\*\*Make sure Nut Plate Thread protected use paint screw \*\*\*\*

M110939.

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

BR 09-04-14 ④

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/14 ④

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Date: Thursday, 19/03/2009 11:03:08 AM  
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## Process Sheet

Customer: CQ-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 46575A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D35371

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Wearpad

batch: B45716

FL

22.0

D35373

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

batch: B35697

FL

23.0

D353511

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

batch: B46714

FL

24.0

D353611

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

batch: B46649

FL

25.0

D353523

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

batch: B43406

FL

26.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

batch: B33965

FL

27.0

D353535

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

batch: B38433

FL 09/04/15 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 46575A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

batch: B38905

FL

29.0

MS27039C108

SCREW



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

SCREW

batch: m19185

FL

30.0

AN960C10L

washer



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

washer

batch: m110916

FL

31.0

ALS41032130

Insert



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 ALS4-1032-130

Inserts m108606

or (see QSI 017)

\*

FL

32.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer m109632

FL

33.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw m110467

FL 09/04/15 (1)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

Date: Thursday, 19/03/2009 11:03:08 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 46575A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D26511

Plug



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-1

Plugs

B43990

FL

35.0

D26513

O-Ring



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-3

O-Rings

B43849

FL

36.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M108161

FL

37.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

M109061

FL

38.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B46327

FL

39.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

FL 09/04/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Date: Thursday, 19/03/2009 11:03:08 AM  
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## Process Sheet

Customer: CJJ-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 46575A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291 m 11/10/87  
Sikaflex expiry date: 10/20

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 m 11/10/87  
Sikaflex expiry date: 10/20

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: m 11/10/13

FL ①  
09/04/15

- FL 09/04/15 ①

40.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/04/15 ④

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/15 ④

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-341

Location: 80

PPP Rev: PPP 46575

9/4/16

⑤

SO

43.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/27/15

Job Completion



MF 09-04-24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

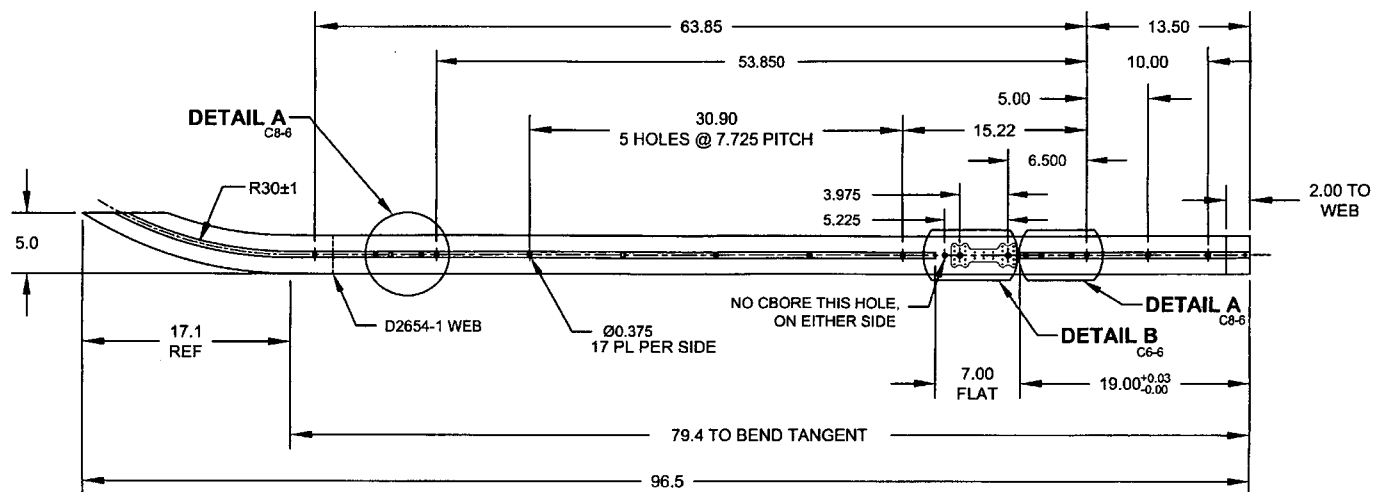
# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

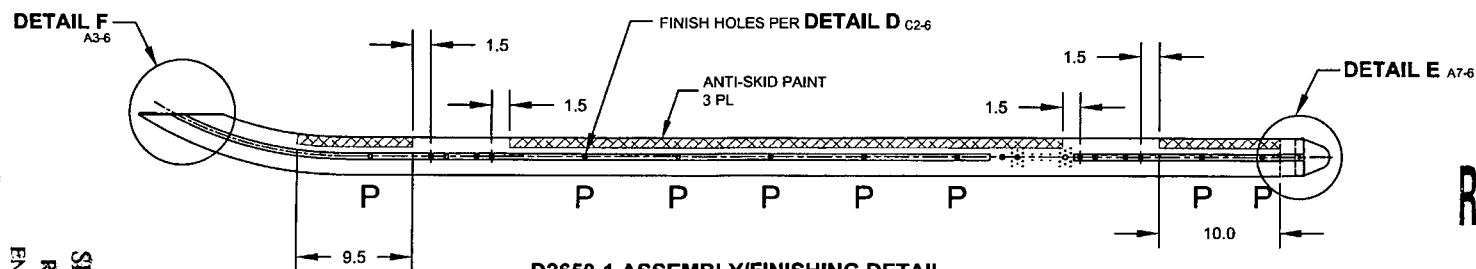
RELEASED  
08-23-19

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
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

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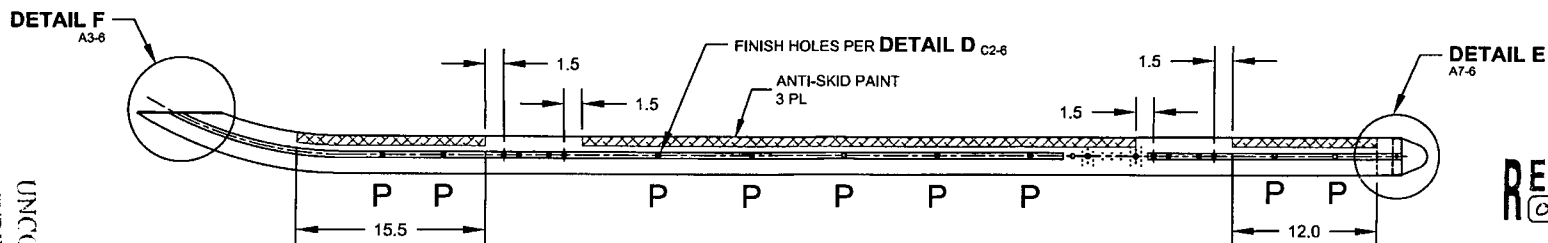
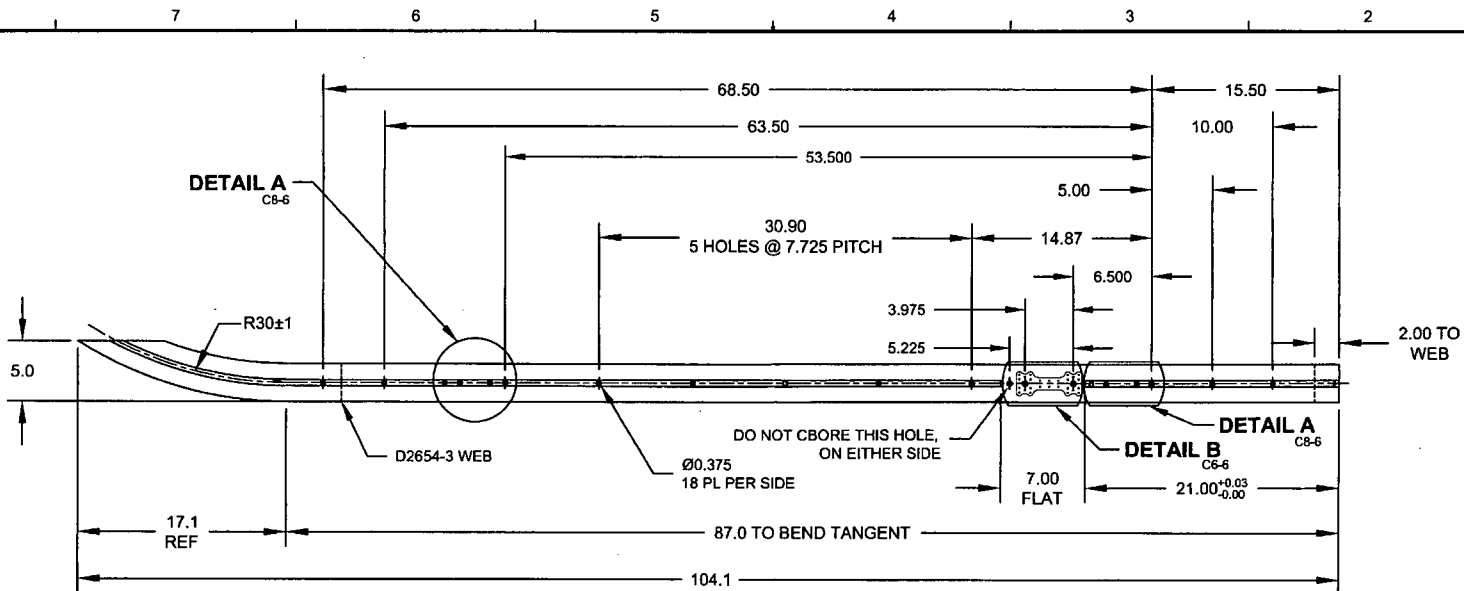


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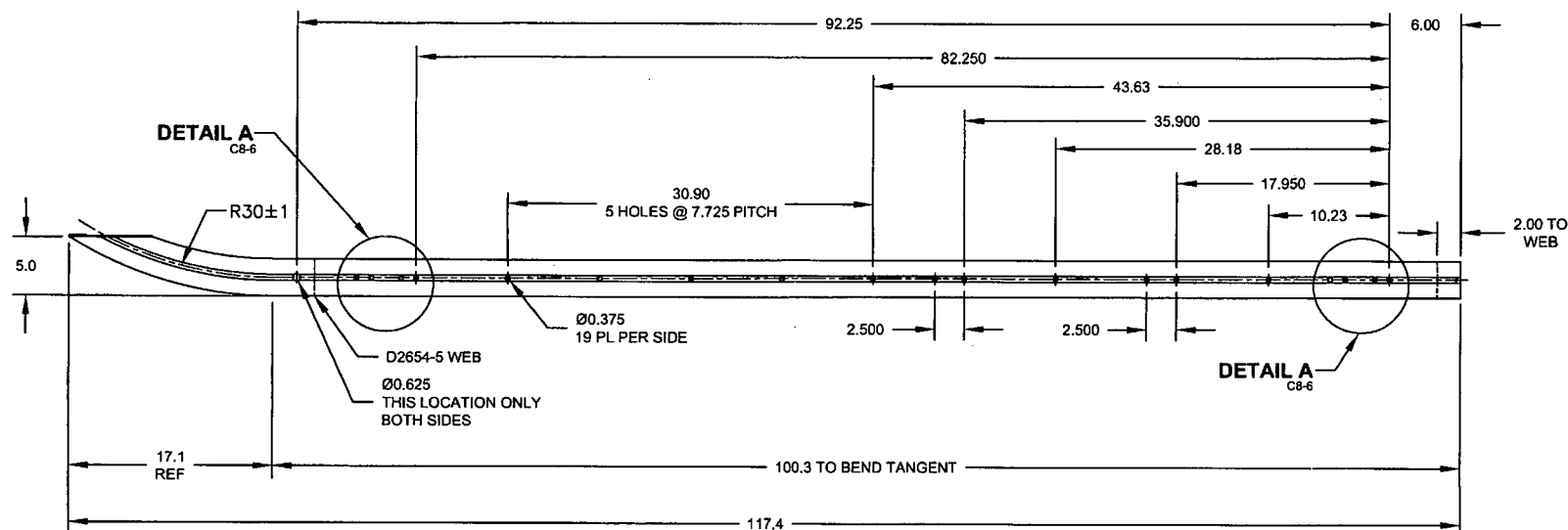


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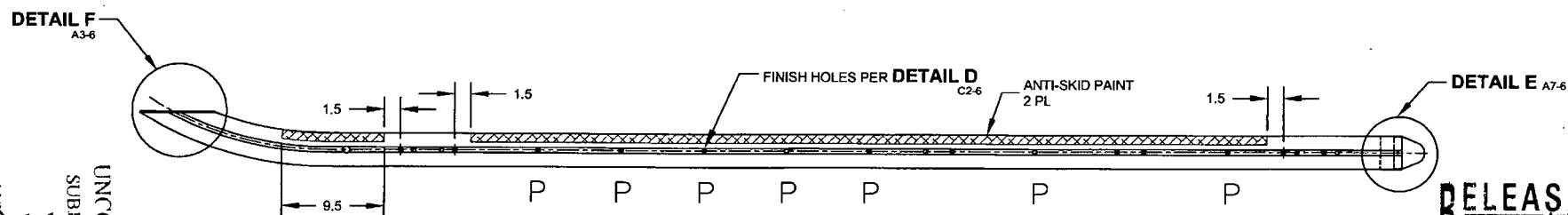
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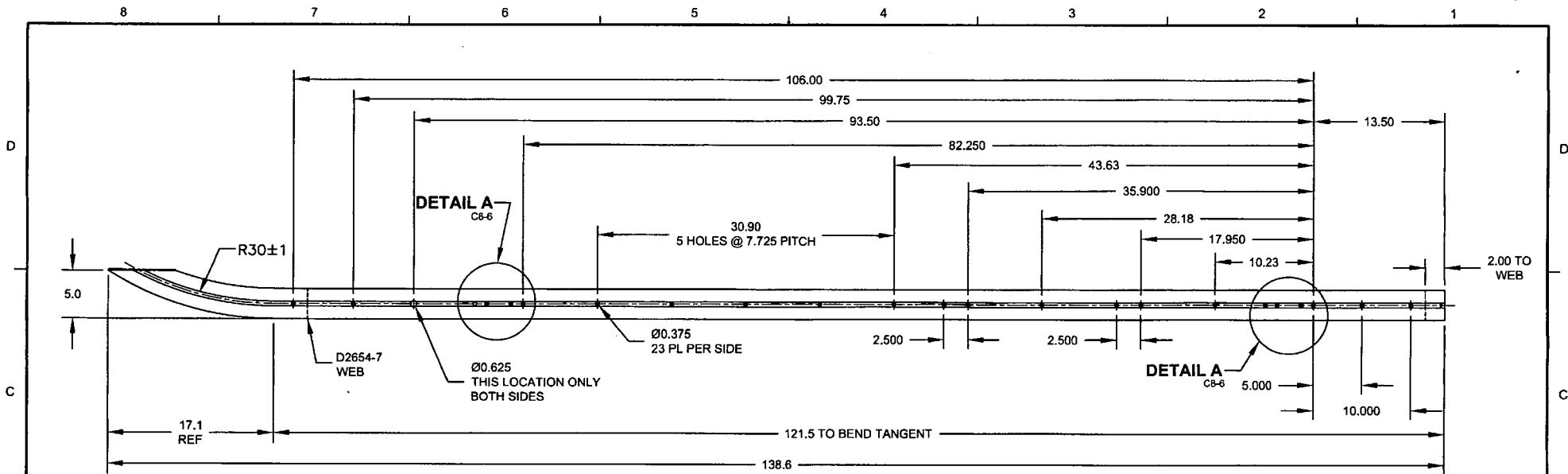


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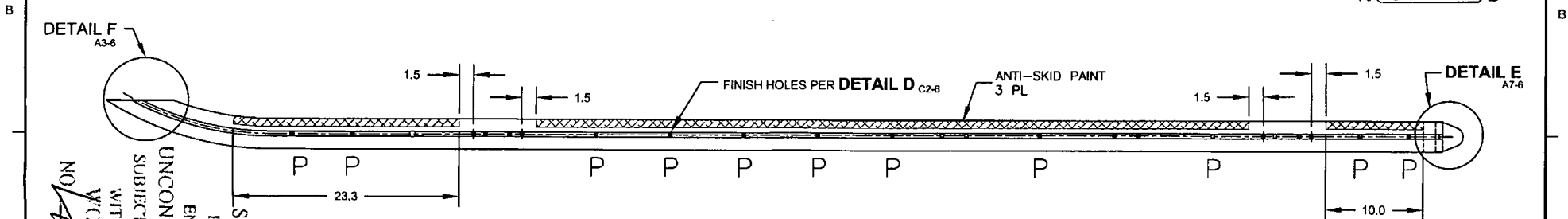
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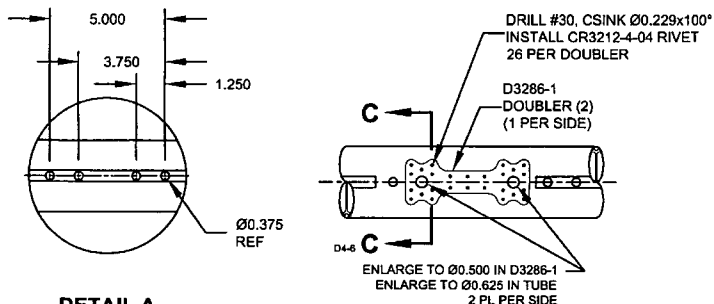
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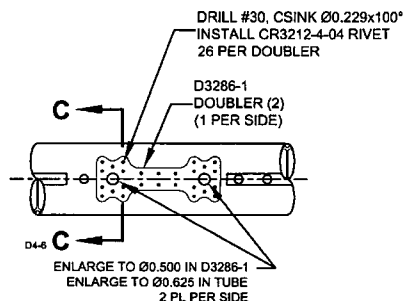


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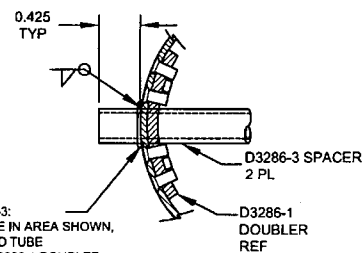


**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

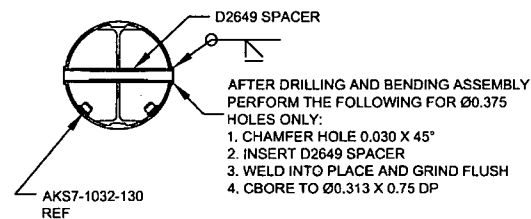


**DETAIL B**  
SCALE 2X  
C3-2  
C3-3

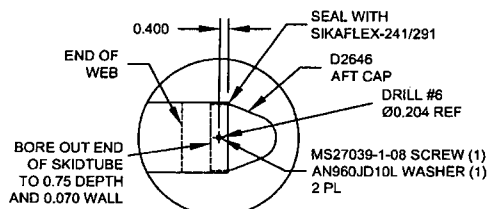
**SECTION C-C**  
SCALE NONE  
C7-6



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5






**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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# **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D206-642 REV. L AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1

REF. CANADIAN STC: SH98-4

REF. FAA STC: SA00475SE

REF. EASA STC: EASA.IM.R.S.01320

## **INSTRUCTIONS:**

1) FOR D206-642-111/-112/-211/-212/-213/-214 SKIDTUBES @ CHANGE 005 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2.
- b) ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2 AND PER FIGURE 1 ON SHEET 4.
- c) REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 2.
- b) AMEND THE PARTS LIST IN SECTIONS 4.1 AND 4.2 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.10 AND 32.11 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 2.

2) FOR D206-642-311/-312/-411/-412 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3.
- b) ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3 AND PER FIGURE 2 ON SHEET 4.
- c) REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 3.
- d) AMEND THE PARTS LIST IN SECTIONS 4.3 AND 4.4 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.12 AND 32.13 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 3.

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4.1 206 A/B Low Gear Skidtubes (D206-642)  
32.10 206 A/B Low Gear Skidtubes (ICA-D206-642)

ITEM	Qty -111	Qty -112	Qty -141	Qty -143	PART NUMBER	DESCRIPTION
	X				D206-642-111	SKIDTUBE INSTALLATION, LH
		X			D206-642-112	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-141	SKIDTUBE
				X	D206-642-143	WEARSHOE KIT
	1	1			D206-651-041	* 206 GHW ADAPTER <sup>®</sup>

IS:

20A			4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1	D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1	D3536-11	GASKET	(ADD)
23A			1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B			1	1	D3536-21	GASKET	(ADD)
24A			1	1	D3535-31	WEARSHOE (REPLACES D2656-31)	(MODIFY)
24B			1	1	D3536-31	GASKET	(ADD)
26A			42		MS27039-1C08	SCREW	(MODIFY)
26B			42		AN960C10L	WASHER	(MODIFY)

WAS:

20A			4		D2648-3	WEARPAD
21A			1		D3429-1	WEARPAD
22A			1	1	D2656-11	WEARSHOE
23A			1	1	D2656-21	WEARSHOE
24A			1	1	D2656-31	WEARSHOE
26A			42		MS27039-1-08	SCREW
26B			42		AN960JD10L	WASHER

4.2 206 A/B High Gear Skidtubes (D206-642)  
32.11 206 A/B High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -211	Qty -212	Qty -213	Qty -214	Qty -241	Qty -243	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-243	WEARSHOE KIT
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER <sup>®</sup>

IS:

20A					4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A					1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A					1	1	D3535-13	WEARSHOE (REPLACES D2656-13)	(MODIFY)
22B					1	1	D3536-13	GASKET	(ADD)
23A					1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B					1	1	D3536-21	GASKET	(ADD)
24A					1	1	D3535-33	WEARSHOE (REPLACES D2656-33)	(MODIFY)
24B					1	1	D3536-33	GASKET	(ADD)
26A					44		MS27039-1C08	SCREW	(MODIFY)
26B					44		AN960C10L	WASHER	(MODIFY)

WAS:

20A					4		D2648-3	WEARPAD
21A					1		D3429-1	WEARPAD
22A					1	1	D2656-13	WEARSHOE
23A					1	1	D2656-21	WEARSHOE
24A					1	1	D2656-33	WEARSHOE
26A					44		MS27039-1-08	SCREW
26B					44		AN960JD10L	WASHER

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4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -343	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-343	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

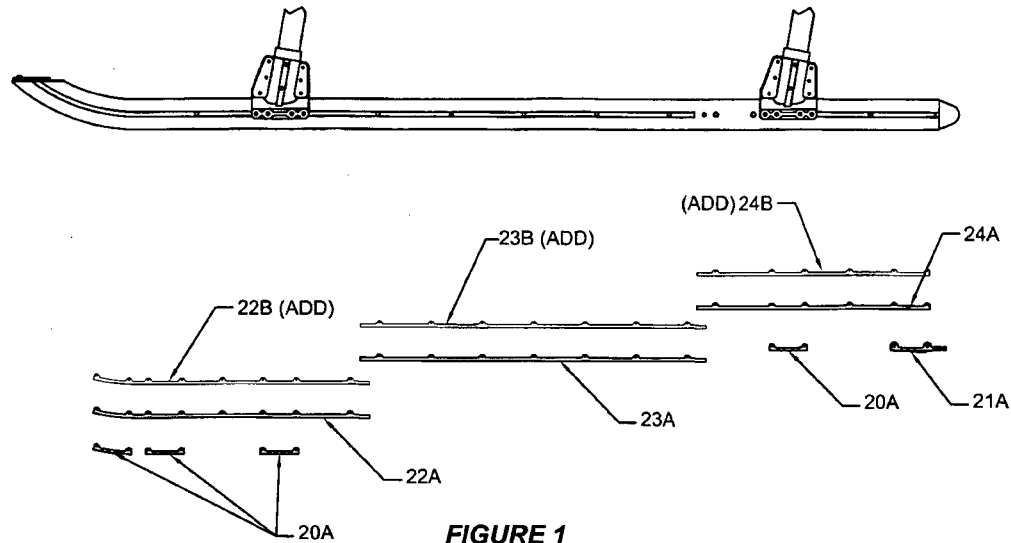
WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

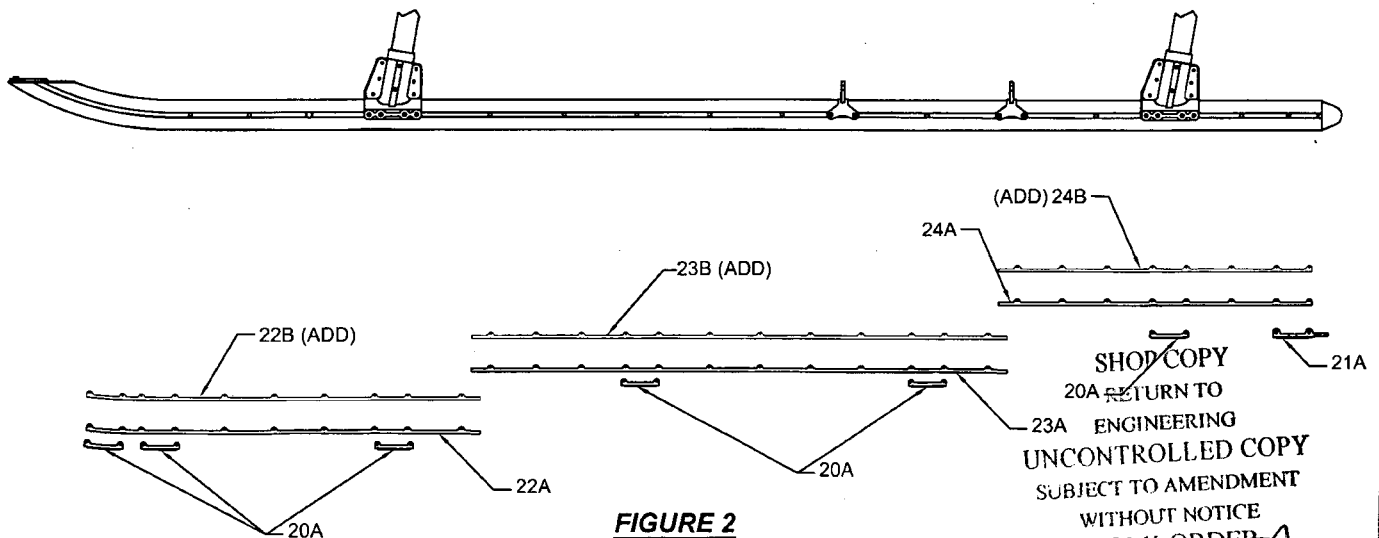
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

**206 A/B SKIDTUBES**  
(D206-642-111/-112/-211/-212/-213/-214)



**206 L/L-1/L-3/L-4/407 SKIDTUBES**  
(D206-642-311/-312/-411/-412)



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APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE CHANGE	NTS
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NO. 194

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 4637590  
Part number: D206 1412 147  
Description: 206 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pet. Djal Date of Test Coupon 09-03-17  
Welder Barclay Elliott Date of Test Coupon 09-03-17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld